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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/03

Rev. No.

01

Rev. Date

31-07-2013

Final Inspection (Pellet Dies) after Hardening & Finishing

S.No.	Check Parameter	Specification	Observations	Remarks
1.	Work order No.		11863	36/10
2.	Visual Inspection	OK - 3.0 mm	(M. drum)	Pro 12/10/11
3.	Pellet Die No.	11229		UT-OK
4.	Hardened by	Lark Penny		Relief OK
5.	Received by after hardening (Name)	J. Sanyal		(3-3) > 20mm
6.	Hardness achieved on 1 st side	50.2 - 50.4 HR	Relief	3.5 5 14mm
7.	Hardness achieved on 2 nd side	50.6 - 50.5 HR	Relief	Counter OK
8.	Ovality after hardening 1 st side	(1.8) mm	[Recounter due to]	POD - 640mm
9.	Ovality after hardening 2 nd side	(2.0) mm	quality.	Tapping M20
10.	Outside Diameter	700 mm		Dep - 13.8mm
11.	Inside Diameter	600 mm		Tapping M16
12.	Width of die	222 mm		Holes - 12
Inspected By (Sign) & Date		J. Sanyal 28/5/14		
1.	Finish Fitting size 1 st side	690 ± 0.05 ± 0.06 mm Tapper 12° ✓		
2.	Finish Fitting size 2 nd side	690 ± 0.09 ± 0.10 mm Tapper 12° ✓		
3.	Finish size made by	_____		
Inspected By (Sign) & Date		J. Sanyal 28/5/14		
1.	Supplied to (Customer Name)	Suguna Foods, Assam		
2.	Dispatch Date	_____		
Reported By (Sign) & Date		J. Sanyal 28/5/14		

Sanyal
28/5/14

Reviewed by (Engineer-CNC)

Manager-CNC